

Work Order ID 51914

Wednesday, September 09, 2009 11:12:00 A



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *RS WW* Date: *09-9-09* Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	Rev F								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

S 02/10/08

HJ for BG 09/10/08

351914

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Item ID: D350-636-012

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Revision ID: F

Item Name: Skidtube RH

Setup Start

Stop

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end								
	2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .								
	3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.								
	4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"								
	5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.								
	6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)								
	7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".								
	8-Open up holes of Detail J to 0.297" (total of 2 holes per side)								
	9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R□□□ Aluminum Rod <input type="checkbox"/> mill 682								
	10-Grind welds flush as per Dwg D2750								

BE 09/09/15

AWM 9-9-16

BE 09/09/15

AWM 9-9-15

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Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11- scribe batch #.

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

2) S 02/02/15

0.00

Memo

④

4

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2) S 02/02/15

0.00

Memo

④

4

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

④

09

09

16

①

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Start Date: 9/10/2009 Start Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

0.00 09-09-16 0

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Item ID: D350-636-012

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Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Skidtubes

Skidtubes

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291batch: 4112391 ☐☐☐exp. date: 02/20/2010

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐☐☐ Aluminum Rod batch: 4111999

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

BE 09/09/07

DP 9-9-26

PD 09.10.01

AWM 9-10-06

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Item ID: D350-636-012

Revision ID: F

Item Name: Skidtube RH




Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Deburr holes								
170  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	27 Sorkolov			(40)	φ		
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27 Sorkolov			(40)	φ		
190  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	27 Sorkolov			(X1)	φ		

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Item ID: D350-636-012

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Item Name: Skidtube RH









Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112260 Memo START TIME 12:45 OVEN TEMPERATURE 320° FINISH TIME: 1:15	0.00 0.00		BL09-10-7					
210  QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00		27 H 09/10/08					
220  HandFinish Hand Finishing	HandFinishing Memo Install inserts as per dwg D2750	0.00 0.00		27 H 09/10/08					

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ 1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

X batch: N/A

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as

✓ per dwg D2750

SIKA FLEX 241

BATCH: M112391

EXP DATE: 10/20

✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

✓ 5-Coat all exposed fasteners with "LPS Procyon"

batch: M104251

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8 02/10/08



6

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Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/10/8 702

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

278 out of 100

70

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

6

9/10/8 1

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Item Name: Skidtube RH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13

09-10-8

Picklist Print

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Page 1

Work Order ID: 51914

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	8,753.000	38.0000			

Insert

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

8753

107441

16

110768

8737

X38 41 09/10/08

AN3C5A

Purchased

No

230

Each

642.0000

34.0000

Bolt

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

642

111424

8

111707

334

112314

200

112489

100

X34 41 09/10/08

AN3C6A

Purchased

No

230

Each

1,048.000

4.0000

BOLT

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1048

110372

72

111982

976

X4 41 09/10/08

Picklist Print

Page 2

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Work Order ID: 51914



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A 		Purchased	No			230	Each	172.0000	4.0000			
BOLT												

Warehouse Loc Qty Loc Code

Location

OFFSHORE

M112720

14

258 09/10/08

FG

2

103964

2

Main Warehouse

ST

170

110105

4

110155

14

110665

1

110865

51

111605

50

111649

50

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

167

102180

1

106896

1

110105

65

110847

100

21 258 09/10/08

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Shop Packet Print

Page 2

Picklist Print

Wednesday, September 09, 2009 11:11:59 AM

Work Order ID: 51914

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Start Date: 9/10/2009

Required Date: 9/18/2009


Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	7,340.000	38.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
FP	-44	
112116	-44	
Main Warehouse		
ST	7284	
112116	2284	
112612	5000	

AN960C816L  WASHER		Purchased	No			230	Each	330.0000	1.0000			
--	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

x38 09/10/08

x1 09/10/08

Picklist Print

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Parent Item Name: Skidtube RH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB  Bushing		Manufactured	No			230	Each	272.0000	8.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	272	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	19	
43754	2	
44893	37	
45556	69	
46695	18	
48278	110	

x8 M 09/10/09

D3488-042RevB

Manufactured No



Blade Fitting Assembly, RH

230 Each 9.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
29043	1	
44531	8	

x1 M 09/10/09

Picklist Print

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Work Order ID: 51914

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Parent Item Name: Skidtube RH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-041 RevC		Manufactured	No			230	Each	3.0000	8.0000			

Plug Assembly

Warehouse
Location
Main Warehouse

Loc Qty
B 51584

Loc Code

x8 41 09/10/08

D3492-043 RevC		Manufactured	No			230	Each	0.0000	8.0000			
----------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Plug Assembly

D3535-25 RevB		Manufactured	No			230	Each	11.0000	1.0000			
---------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Wearshoe

Warehouse
Location
Main Warehouse

Loc Qty
B 51663

Loc Code

x1 41 09/10/08

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Shop Packet Print

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Picklist Print

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Work Order ID: 51914



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA		Manufactured	No			230	Each	21.0000	1.0000			

Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

45569

1

47011

2

47526

8

50266

10

D3537-1RevC

Manufactured No

230

Each

45.0000

3.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

45

48288

2

50321

43

1351918

x1 21 09/10/08

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Parent Item Name: Skidtube RH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA		Manufactured	No			230	Each	105.0000	8.0000			
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1351968

105

38139

6

45353

16

47437

83

48 21 09/10/08

D3791-1RevA

Manufactured No



230

Each

18.0000

1.0000



Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

X1 21 09/10/08

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA		Manufactured	No			230	Each	18.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code
Location


Main Warehouse

ST 18

40551 1

47537 4

50231 13

D3793-3RevA		Manufactured	No			230	Each	22.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 22

47720 11

50216 11

x1 44 09/10/08

x1 44 09/10/08

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-1RevA		Manufactured	No			230	Each	33.0000	1.0000			

Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 33

46530 1

47212 2

47721 4

51668 26

D3794-3RevA

Manufactured No

230

Each

27.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 27

46531 2

47440 2

47722 11

50240 12

41 28 09/10/09

41 28 09/10/09

Picklist Print

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Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:


Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6  NUT		Purchased	No			230	Each	1,132.000	4.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1132	
110584	34	
111424	98	
112314	1000	

x4 09/10/08

MS21083C8  NUT		Purchased	No			230	Each	90.0000	1.0000			
--	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	90	
110584	5	
111424	2	
111637	21	
112243	42	
112492	20	

x1 09/10/08

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-010		Purchased	No			230	Each	345.0000	8.0000			
O-RING												

X

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

D2594-3/B51613

x8 09/10/08

* PTO LAST PAGE

=>

NAS1611-013

Purchased

No

230

Each

320.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758

200

x8 09/10/08

Wednesday, September 09, 2009 11:11:59 AM

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Page 11

WFO: 51914

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/08	MA	Replace NAS 1611-010 for 02594-3 / B51613 "O" rings	M	09/10/08	x8		G 09/10/08

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Wednesday, September 09, 2009 11:11:59 AM

Work Order ID: 51914

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A BOLT		Purchased	No			260	Each	110.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	110	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
111684	50	

111684 SC

AN960C816L

Purchased

No

260

Each

330.0000

2.0000

WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

111424 9/10/8 @ SP

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Wednesday, September 09, 2009 11:11:59 AM

Work Order ID: 51914

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2741RevC

Manufactured

No

260

Each

40.0000

1.0000



Blade, 350 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

47113 sc

D3493-1RevA

Manufactured

No

260

Each

115.0000

2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

44902

15

47710

100

47710 sp

D3532-1RevA

Manufactured

No

260

Each

43.0000

2.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

44904

9/10/08 WJ

Wednesday, September 09, 2009 11:11:59 AM

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Page 13

Picklist Print

Wednesday, September 09, 2009 11:11:59 AM

Work Order ID: 51914

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			260	Each	90.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	90	
110584	5	
111424	2	
111637	21	
112243	42	
112492	20	

112243 54

NAS1515H3L



WASHER

Purchased

No

260

Each

350.0000

4.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819	300	

24 09/10/09

Picklist Print

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Wednesday, September 09, 2009 11:11:59 AM

Work Order ID: 51914

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/10/2009



Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L  WASHER		Purchased	No			260	Each	127.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	127	
107581	34	
108964	1	
111650	92	

D2600-3-BENTRevD1  Extrusion Bent		Manufactured	No			110	Each	0.0000	1.0000			
D2744RevC  Cap		Manufactured	No			110	Each	50.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	50	
44892	15	
47488	35	

111650 sp 9/10/08 92

506751 BE 09/09/15

BE 09/09/15

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Wednesday, September 09, 2009 11:11:59 AM

Work Order ID: 51914

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD 		Manufactured	No			160	Each	6.0000	1.0000			
350 I Beam												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

D2743RevB

Manufactured No

160

Each

294.0000

8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

50

50281

50

Main Warehouse

ST

244

44891

2

45555

177

48275

65

8 PD 09-09 09-10-01

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Wednesday, September 09, 2009 11:11:59 AM

Work Order ID: 51914



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH


Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA  Cross Bolt Spacer		Manufactured	No			160	Each	112.0000	4.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

112

45560

22

47471

35

48276

55

BS1930 → 4

PD 09.10.01

D3490-1RevA



Cross Bolt Spacer

Manufactured No

160

Each

165.0000

4.0000



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

165

45338

2

47118

4

47657

50

48277

109

4 PD 09.10.01

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

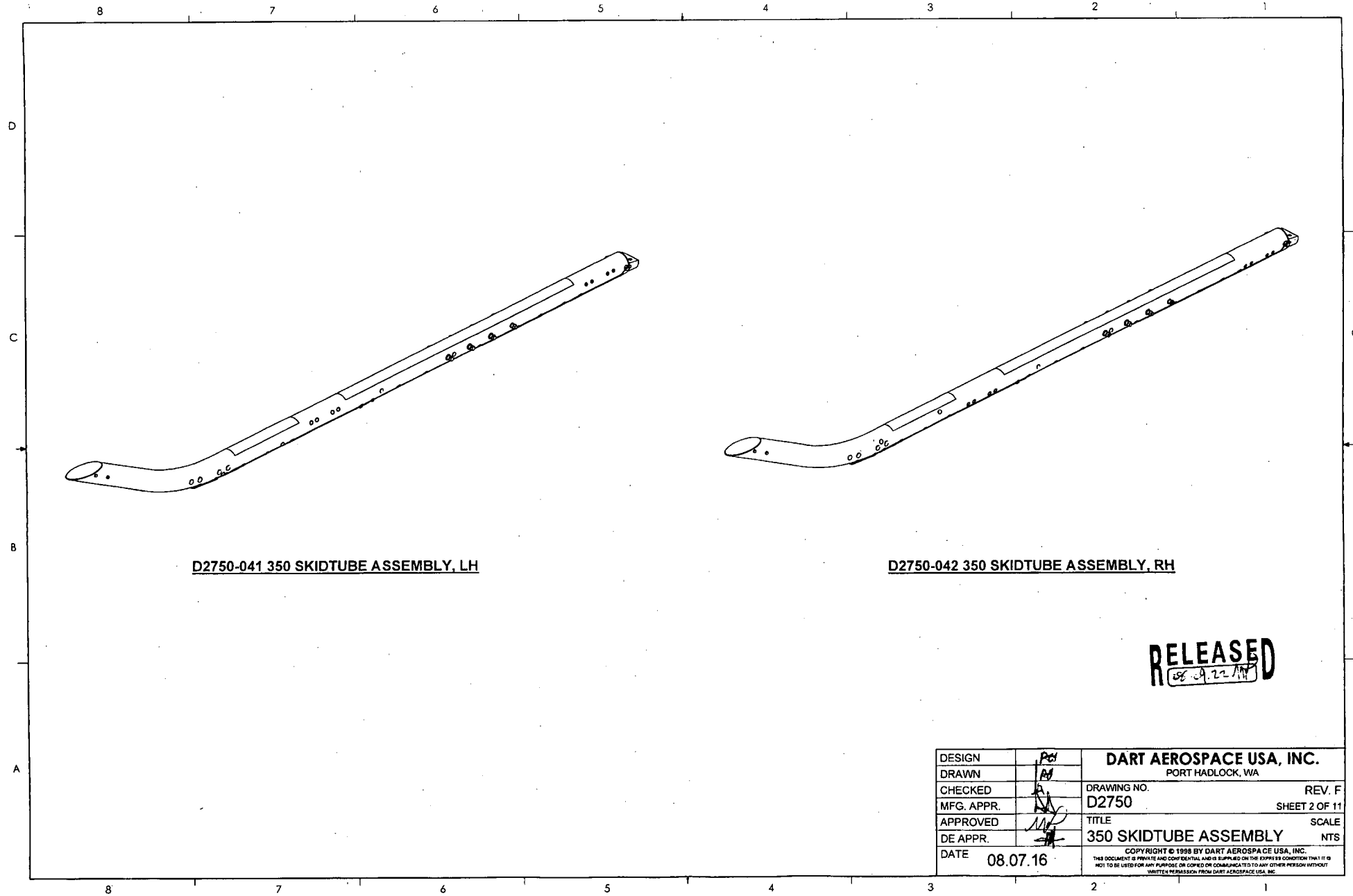
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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NO. 51914

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F SHEET 1 OF 11	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
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w/051914



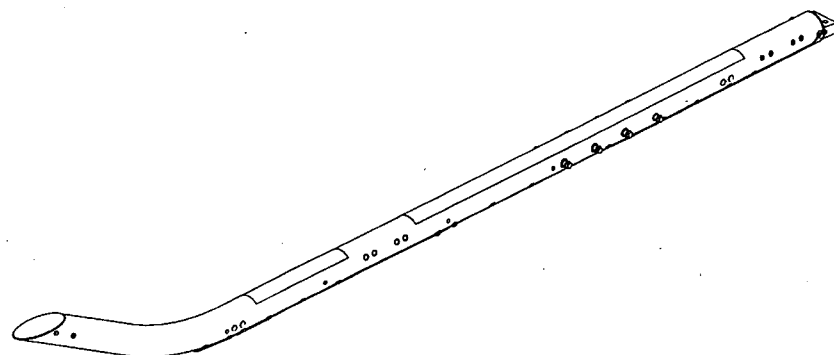
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

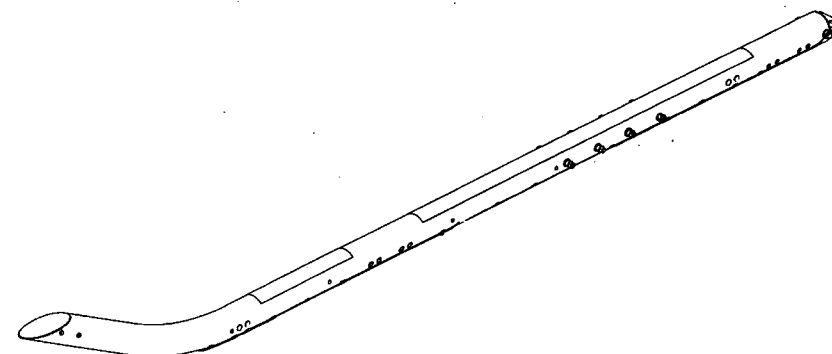
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CHECKED	SA	DRAWING NO. D2750	REV. F
MFG. APPR.	SA	SHEET 2 OF 11	
APPROVED	ME	TITLE	SCALE
DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
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W/O 51914



D2750-043 350 SKIDTUBE ASSEMBLY, LH

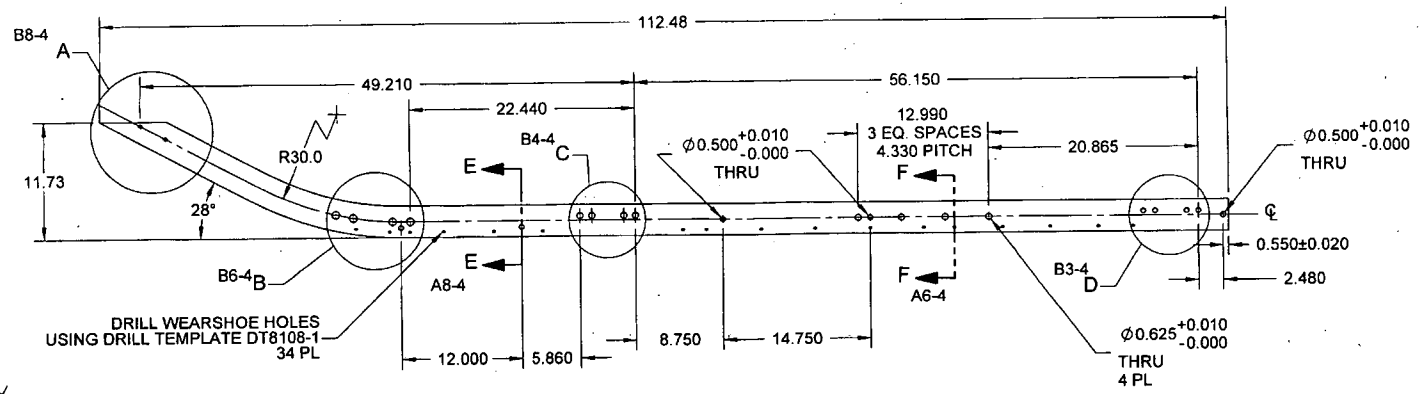


D2750-044 350 SKIDTUBE ASSEMBLY, RH

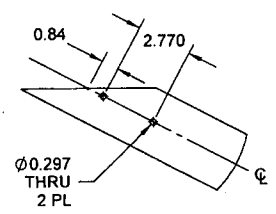
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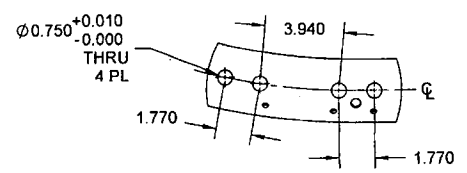
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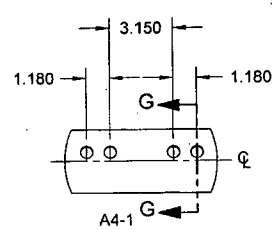
D2750-1 LH SKIDTUBE



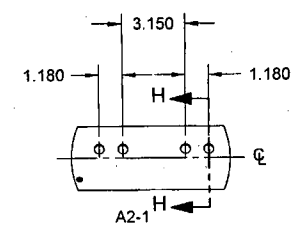
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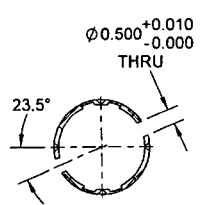
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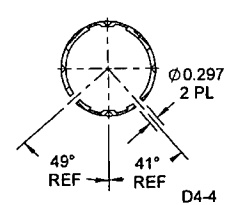
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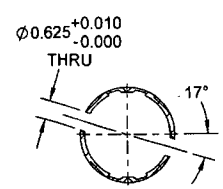
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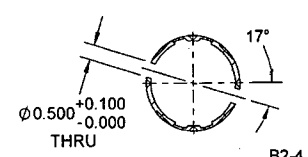
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SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

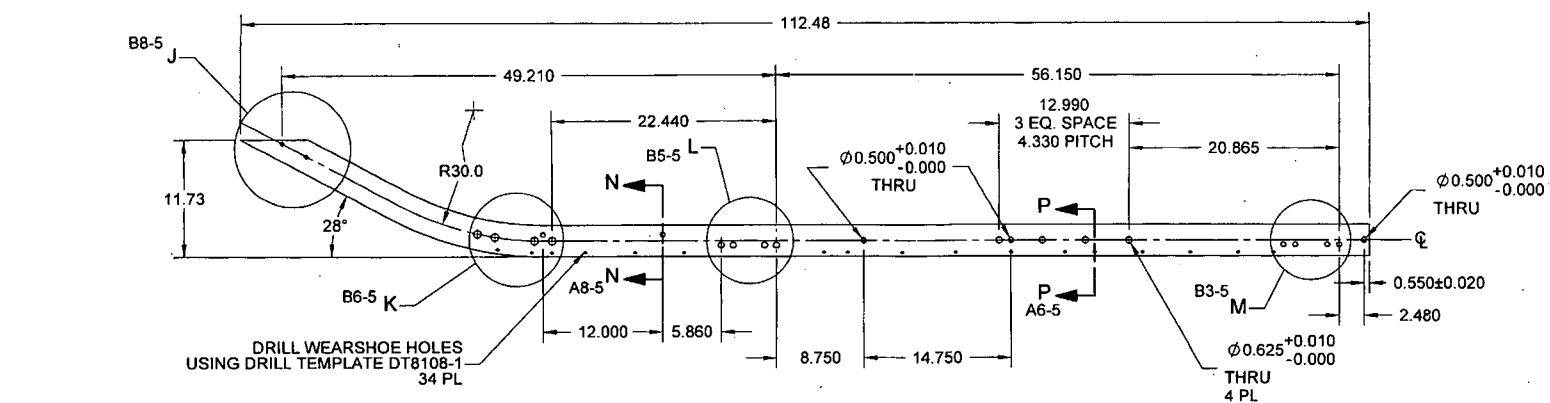


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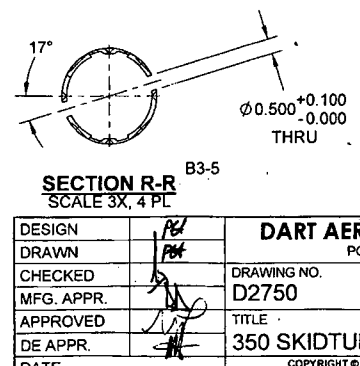
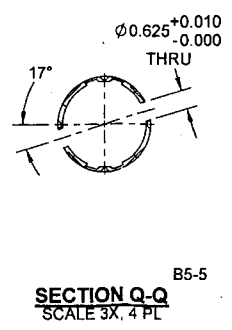
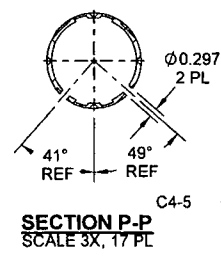
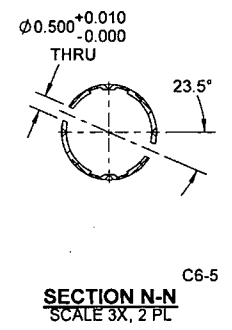
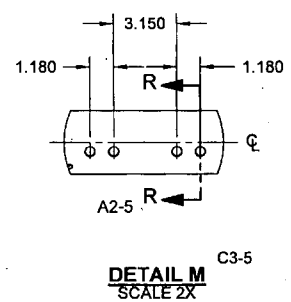
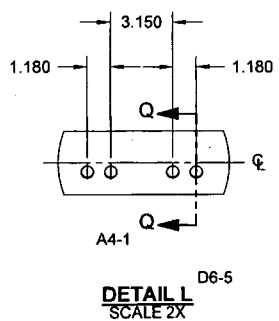
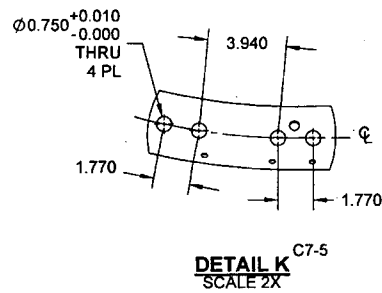
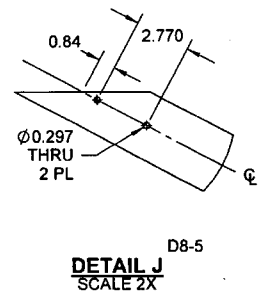
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MFG. APPR.		D2750	SHEET 4 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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51914



D2750-2 RH SKIDTUBE

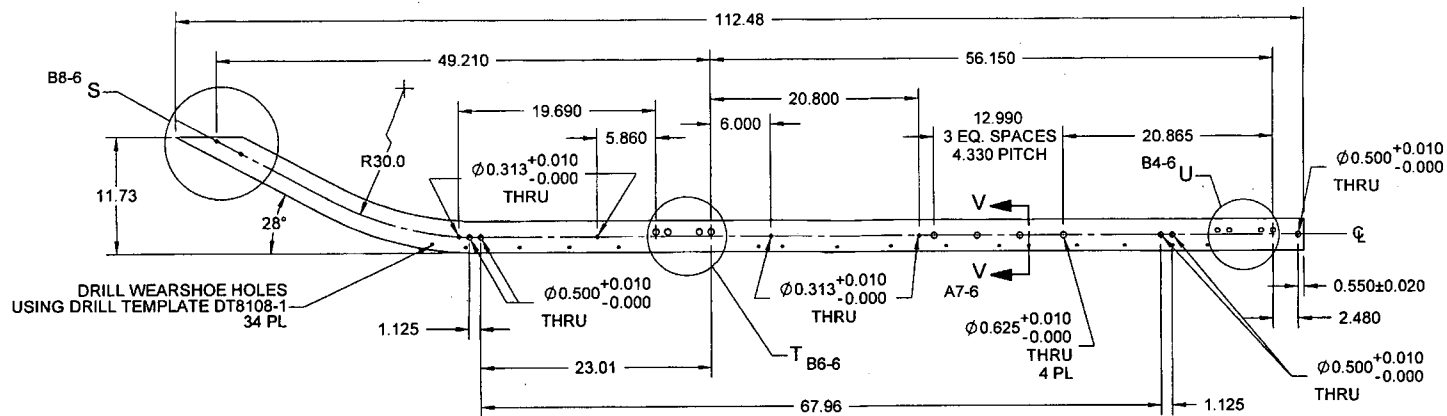


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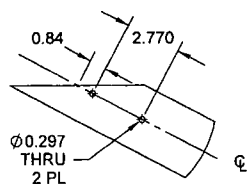
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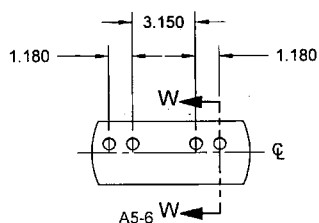
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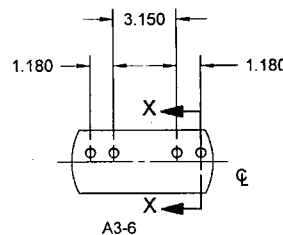
D2750-3 LH SKIDTUBE



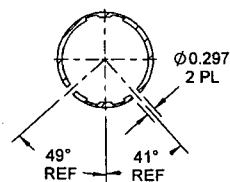
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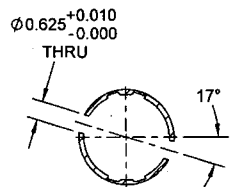
DETAIL T
SCALE 2X



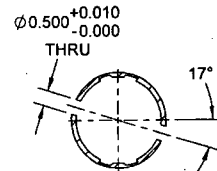
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



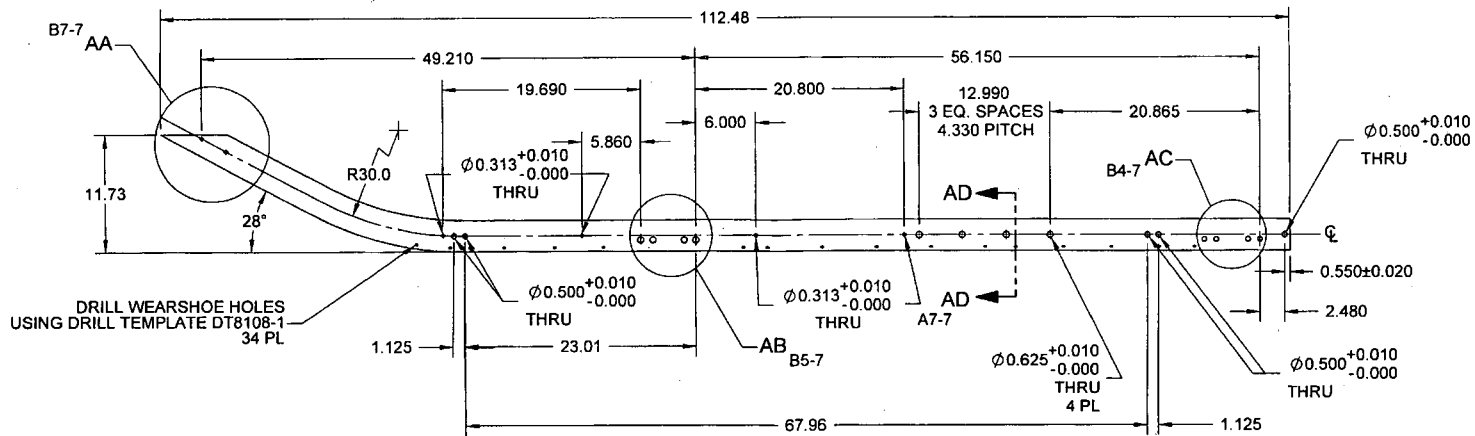
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08-22-11

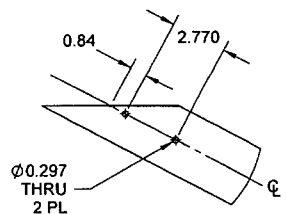
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MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
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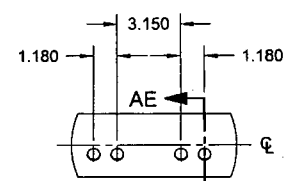
4/0 51914



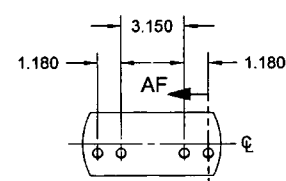
D2750-4 RH SKIDTUBE



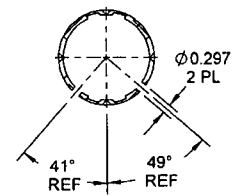
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SCALE 2X



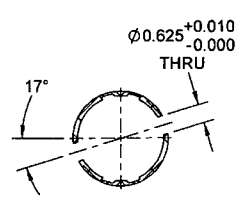
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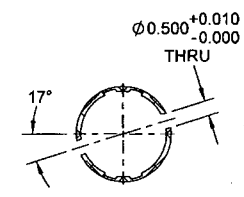
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

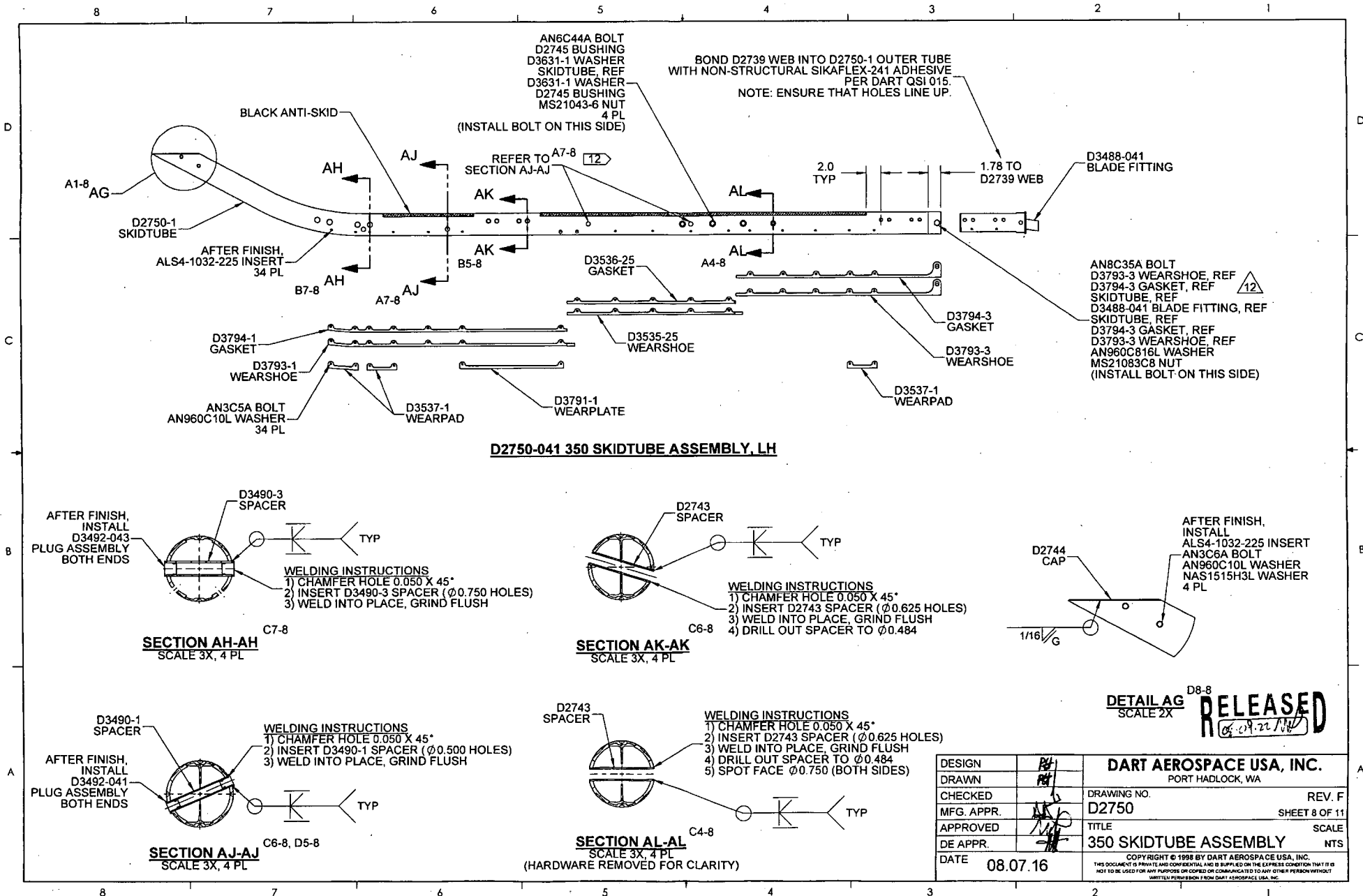


SECTION AF-AF
SCALE 3X, 4 PL

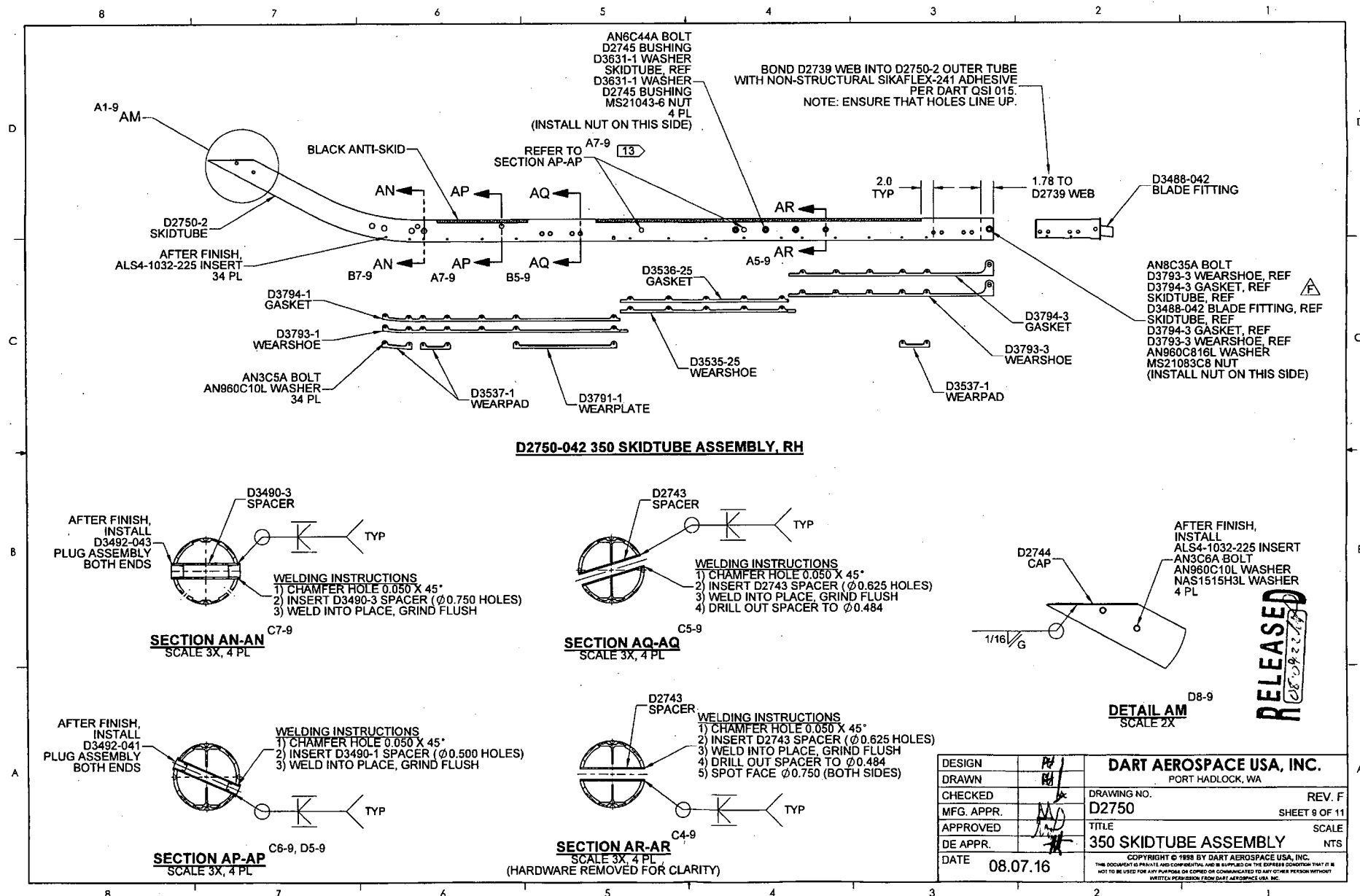
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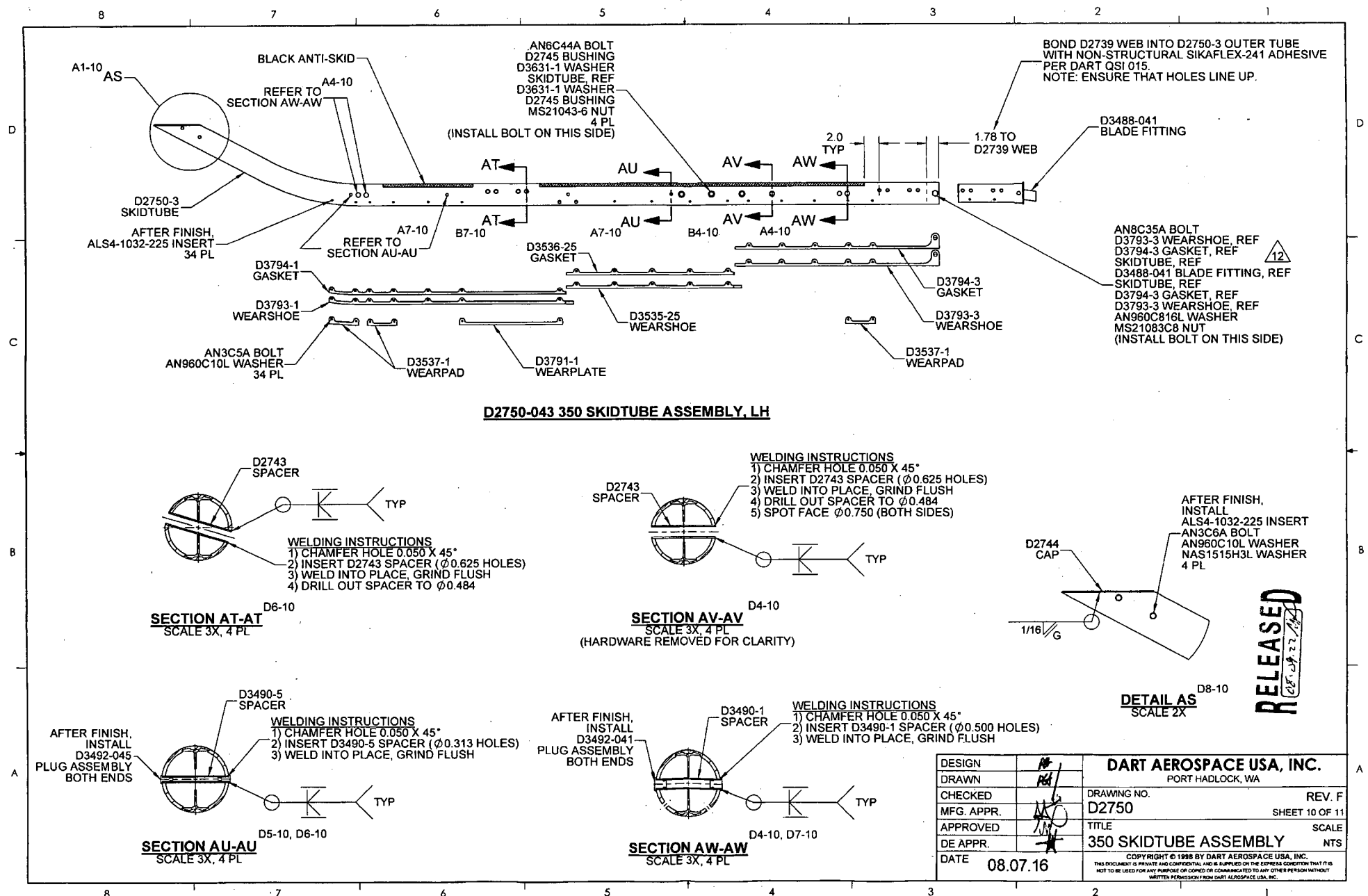
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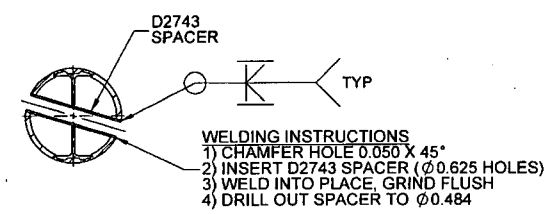
w/o w/o 51914



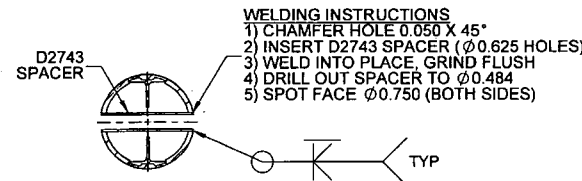
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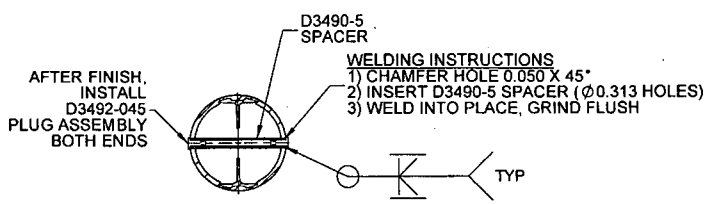
D2750-043 350 SKIDTUBE ASSEMBLY, LH



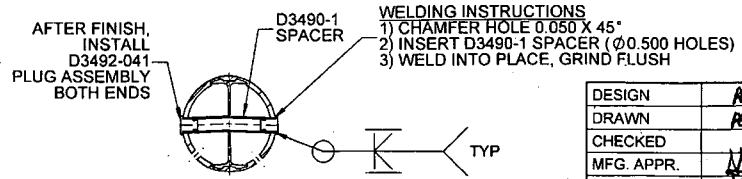
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SCALE 3X, 4 PL



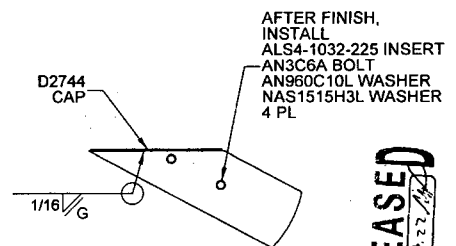
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

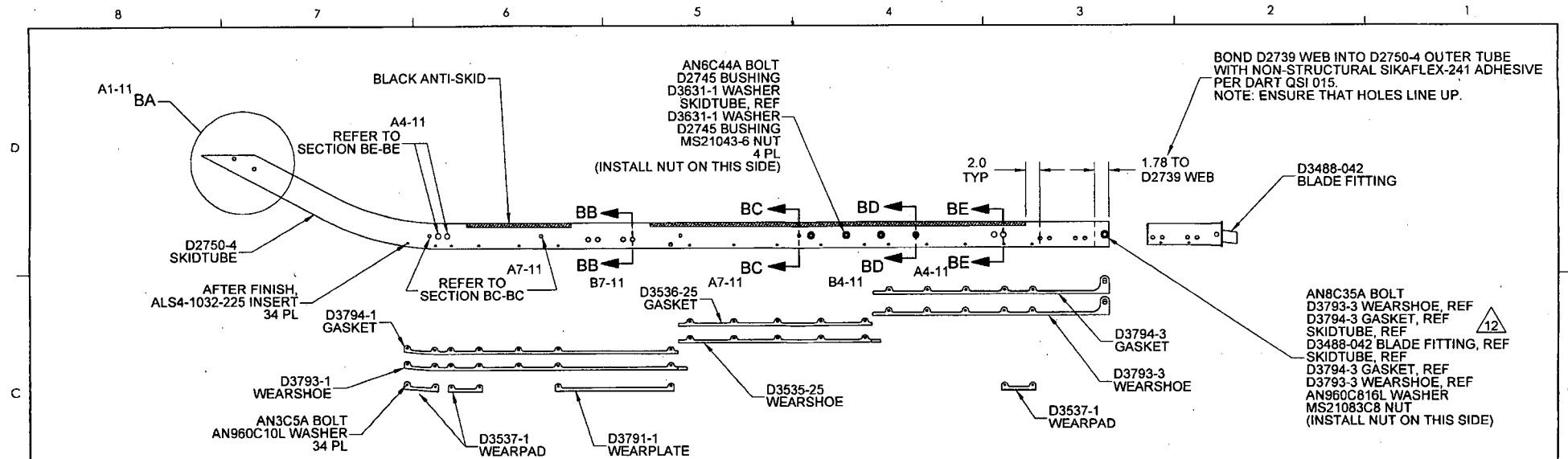


DETAIL AS
SCALE 2X

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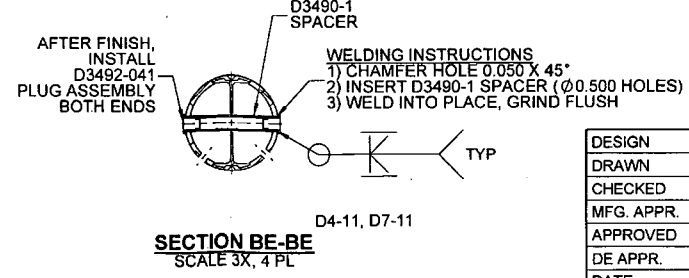
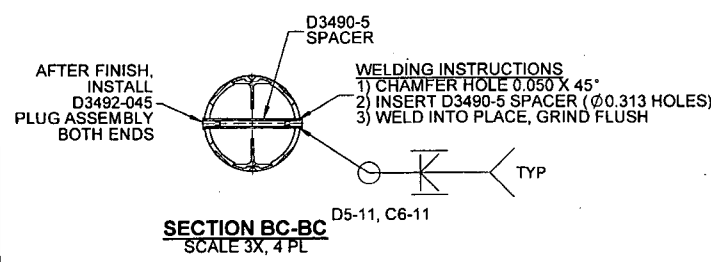
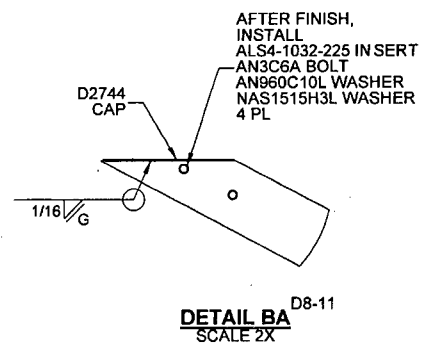
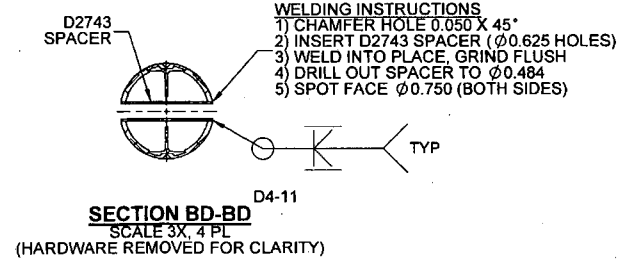
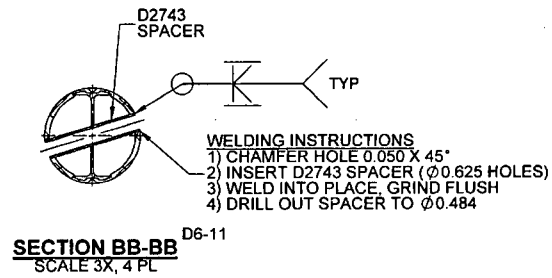
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W/O 51914



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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NO. 209

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: A. R. Avel
Job number: 51803
Part number: A350-636-011
Description: 350 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Davel Date of Test Coupon 09/09/28
Welder Pat. Paul Date of Test Coupon 09.09.28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld